Work Order ID 998 Friday, April 12, 2013 3:24:4		0	*998	90*		Ac	AP.		Page
Item ID: D4125-1 Revision ID: Item Name: Sump Start Date: 4/12/2013 Required Date: 4/19/2013 Reference:	Start Qty: 6.00 Req'd Qty: 6.00	°6* *6*	Accept	*N900 Cust Item II Customer:	70 A	n* s	Setup Sta	IV	S1* S2*
Approvals: Process Plan QC:	: YMF.	Date: 13-4-	Tooling: SPC (Y/N):		ite:	F	Run Sta Sto	1/1	R1* R2*
Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr Revis	sion Nbr				Mad president	1807			
D4125 C	1		A.						il the
*100 *100* Bandsaw Jeaspa Bandsaw	Memo I-Cut Blank a	ut 13.375"	0.00	13/04	/25	10	Ø		
	4.5						=		
*105 *105* HAAS 1 HAAS CNC vertical machine #1	Memo Machined as p Rev: Dwg:	per folio FB078	0.00 (D	13/05/01 13/04/29		10	Ø	eg/	
	Deburr								

A

									DQA:	Date:	3 4 0
NCR: Y	es / No				WORK ORDER NON-	CONF	DRMANCE / U	PDATE	QA Closed:	Date:	
		1			DISPOSITION	\top		AGAINST D	DEPARTMENT,		
Work Order Part No	0.				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining nermoforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initi		Action scription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
					Y F	AULT C	ATEGORY				
Landin	Bending Centre N Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at on Strip in n Bend Vaves in	Tube Extrusion	S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Ins Ins Ma Mis Off	rdware pection Incomplete tructions Incomplete sintenance slabeled sread	_	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Waye/Tu				Teolio	Ou	tside Dimensions				

DQA:

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Friday, April 12, 2013 3:2	99890 4:41 PM	*998	890*			Page
Item ID: D4125-1 Revision ID: Item Name: Sump Start Date: 4/12/2013 Required Date: 4/19/2013 Reference:	Start Qty: 6.00 *6*	Accept	*N900040100 Cust Item ID: Customer:	n* s	Setup Start Stop	17.71
Approvals: Process QC:	Plan: Date: Date:	Tooling: SPC (Y/N):	Date:	F	Run Start Stop	"INK I"
Sequence ID/ Work Center ID	Operation Description QC2- Inspect parts off machine FAI/FAIB	Set Up/ Run Hours 0.00	Tool ID Tool # Plan Code 0 13/05/01 13/04/29	Accept Qty 1		Reject Insp. Number Stamp
QC Quality Control	Мето	0.00		7.0		
*120 *120* QC	QC8- Inspect parts - second check Memo	0.00	a 13/05/01	1	ø	08

Hand Finishing

NCR:	Yes /	No

WORK ORDER NON-CONFORMANCE / UPDATE

DISPOSITION

T F	DQA:	Date:	*
TE	QA Closed:	Date:	
AGAINST D	EPARTMENT	/PROCESS	
Crosstube Small Fab Finishing Composite	_	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
ion	Sign & Date	Verification	QC Inspector

Part No NCR No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T	T		Descrip	otion of work order update	te	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		r Non-conformance		ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
		1				FAUI	T CATE	GORY				
Landing	Gear				General							
	Cracks Crushed, Cuffs Heat Tre Inspection Ripples i Torque V	lot Conce /Crimped at on Strip in n Bend	Tube Extrusion	/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/U nance led	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tu	wist in Tu	be		Folio		Outside	Dimensions		×		

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Work Order ID 99890 *99890* Page 3 Friday, April 12, 2013 3:24:41 PM Item ID: D4125-1 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Sump *NS2* Start Date: Start Qty: 6.00 *6* 4/12/2013 Cust Item ID: Required Date: 4/19/2013 Req'd Qty: 6.00 Customer: Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp 140 QC3- Inspect Part Finish 0.00 *140* 0.00 Memo Quality Control 150 Identify as per dwg & Stock Location: 1114 503 0.00 *150* Packaging 0.00 Memo Packaging 160 QC21- Final Inspection - Work Order Release 0.00 *160*

0.00

Memo

Quality Control

pl 13-05-2

NCR: Y	es / No			1	WORK ORDER NON-	CONFOR	MANCE / UP	DATE			*
									QA Closed:	Date	e:
Work Orde	r:				DISPOSITION	_		_	EPARTMENT	·	
Part N NCR N					Rework Scrap Use-as-is Work Order Update	- 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	- 10 - 10	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descripti	on of work order update	Initial	Ac	tion	Sign &		1
Cause	Date	Step	Qty	orl	Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
						FAULT CATI	GORY				
Landin	Bending Centre N Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque V	Crimped at n Strip in n Bend Vaves in I	Tube	BBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBBB	General end OM/Route roken/Damaged urrs ontamination ountersink ut Too Short rill Holes rawing	Instruction Maint Mislab Misrea Offset Out of	tion Incomplete tions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \(\) Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Mayo/Ty				nlio	10.000000000000000000000000000000000000	e Dimensions				

DQA:

Date:

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Picklist Print

Friday, April 12, 2013 3:24:41 PM

Work Order ID:

99890

Parent Item:

D4125-1

Parent Item Name:

Sump

Start Date: 4/12/2013

Required Date: 4/19/2013

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 10.07.21 new issue DD verf:EC

IPP Rev:B 11/12/05 as per dwg, rev.B JFS verf:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X08.000		Purchased	No			100	f	4.7370	1.115	7.0421053			
6061-T6 BAR 2.00' X 8.00'	Marie II. III									710121000	PO	13/04	1/25

Loca	ation	Loc Qty	Loc Code
MAT	005	4.737	
	123089	0.085	
	124443	3.252	
	125034	1.4	

A 125386

NCR: Y	es / No				WORK ORDER NON-	CON	IFORM	ANCE / UPDATE		QA Closed:	Date:	
Work Ordon					DISPOSITION			AGAIN	NST DE	PARTMENT	/PROCESS	4
Part No	0.				Rework Scrap Use-as-is Work Order Update		M Thermo	kid-tube Crosstu achining Small I oforming Finish arge Fab Compos	Fab	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	Desc	cription of work order update		nitial ief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						AUL	T CATEG	ORY				-
Landin	g Gear Bending Centre N Cracks Crushed/ Cuffs Heat Trei Inspection Ripples in Torque V	Crimped at on Strip in n Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		DOMESTIC OF THE PARTY OF THE PA	n Incomplete ens Incomplete/Unclear ance		Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

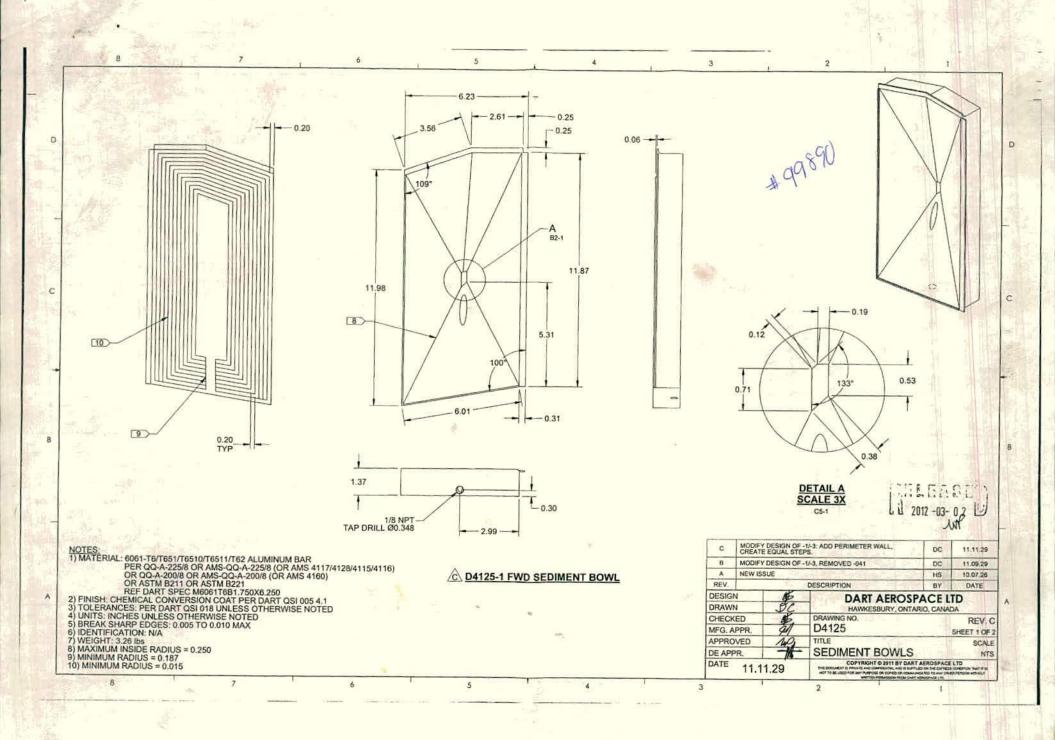
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Turning Sequence

Wave/Twist in Tube

Finish

Folio



		11				MANCE / UPD		QA Closed:	Date:	
).).				DISPOSITION Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	AGAINST D Crosstube Small Fab Finishing Composite	Pro	Water Jet d. Eng. Coor.	Engineering Quality Other
Date	Step	Qty			Initial Chief En	1900-32-0		Sign & Date	Verification	QC Inspector
-	-			F	AULT CAT	EGORY				
Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque V	Crimped at n Strip in n Bend Vaves in E	Tube	/5	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Hardv Inspect Instru Main Mislal Misre Offset Out o	rare tion Incomplete ctions Incomplete/U tenance peled ad	Inclear	Part Incorre Part Lost/M Part Moved Positioned V	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Date Date Gear Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W	Date Step Date Step Gear Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend Torque Wayes in E	Date Step Qty Gear Bending Centre Not Concentric to O, Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube	Description Date Step Qty Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Wayes in Extrusion	Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Fagear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Rework Scrap Use-as-is Work Order Update or Non-conformance Fagear General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Chief Eng Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Drawing Out of Out of One of Work Order update or Non-conformance Initial Chief Eng FAULT CAT General Bend Grain General Bend Hardw Hardw Hardw Inspection Strip in Tube Contamination Maint Countersink Mislat Cut Too Short Misres Offset Drawing Out of Out	Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Initial Large Fab Date Step Oty Description of work order update or Non-conformance Chief Eng Description Of Work Order Update Initial Chief Eng Description Of Work Order Update Or Non-conformance Chief Eng Description Of Work Order Update Or Non-conformance Order Eng Description Of Work Order Update Or Non-conformance Order Eng Description Of Work Order Update Or Non-conformance Order Eng Description Order Eng	Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Use-as-is-as-as-is Use-as-is-as-as-as-as-as-as-as-as-as-as-as-as-as	Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Large Fab Composite Finishing Composite Rec/Sto Date Step Qty Description of work order update Or Non-conformance Chief Eng Description Date FAULT CATEGORY General Bending Contre Not Concentric to O/S Broken/Damaged Inspection Incomplete Burrs Instructions Incomplete Inspection Incomplete Inspection Incomplete Contre Not Concentric to O/S Broken/Damaged Inspection Incomplete Instructions Incomplete Contre Not Contamination Maintenance Part Moved Heat Treat Inspection Strip in Tube Ripples in Bend Countersink Misread Drill Holes Offset Order Out of Calibration Drawing Out of Calibration	Rework Scrap Use-as-is Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Verification Dat

Outside Dimensions

DQA:

Date: .

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Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order: 99890	
Description: Fwd Sediment Bowl	Part Number: D4125-1	5
Inspection Dwg: D4125 Rev: C	Page 1 of 1	NY.

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.20	+/-0.030	-200	7			1
6.23	+/-0.030	6.236	~			V.
3.56	+/-0.030	3,563	7		-	
2.61	+/-0.030	2.611	7		3.3	
0.25	+/-0.030	.25	7		1 1	
0.25	+/-0.030	.25	7			
11.87	+/-0.030	11.866	V			
0.31	+/-0.030	.32	7	7"		
6.01	+/-0.030	6.01	V			
11.98	+/-0.030	11,98	7			
0.06	+/-0.030	.06	7			
1.37	+/-0.030	1,368	7			
2.99	+/-0.030	2.99	>			
0.30	+/-0.030	,30	1			
Ø0.348	+0.006/-0.001	.348	7			
		6.				

Measured by:	F.t./PD	Audited by:	DA , DAS	Preliminary Approval:	
Date:	13/04/29	Date:	13/05/01 00	Date:	

Rev	Date	Change	Revised by	Approved	
Α	12.09.26	New Issue	KJ 🔾	CM/	
			7	///	

NCR:	Yes	/ No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	1.35		
			21	
DA Closed:	Date:			

							QA Ciosea: Da	ite:	
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No.				Rework Scrap Use-as-is Work Order Update	Mac Thermofo	d-tube Crosstub chining Small Fa prming Finishin ge Fab Composit	Prod. Eng. Coor. g Rec/Store/Packaging	Quality Other	
Root	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Verification	on QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other	e Cey		¥-			1.			
Process Supplier Training Unapproved									
		-70	4		FAULT CATEGOR	RY		A PART OF THE PART	
Landing	Gear Bending Centre No Cracks Crushed/		ntric to	General Bend BOM/Route Broken/Damaged Burrs		ncomplete ** s Incomplete/Unclear	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
	Cuffs Heat Trea	at	Tube	Contamination Countersink Cut Too Short	Maintenar Mislabeled Misread	Of the Control Design Control of the	Part Moved Positioned Wrong Power Loss/Surge	Other	
	Ripples in Torque W Turning S	n Bend Vaves in E Sequence	Extrusion	Drill Holes Drawing Finish	Offset Out of Calib	ience			
	Wave/Tw		oe . (vicevii	Folio	Outside Din	nensions			